

Work Order ID 61251

August 11, 2010 11:56:40 AM



Page 1

Item ID: D2524

Accept



Setup Start



Revision ID:

Stop



Item Name: Bracket Clamping

Start Date: 8/11/10 Start Qty: 5.00



Cust Item ID:

Required Date: 8/18/10 Req'd Qty: 5.00



Customer:

Reference:

Run Start



Approvals: Process Plan: CZ Date: 10/8/11 Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

| Sequence ID/ Work Center ID | Operation Description | Set Up/ Run Hours | Tool ID | Tool # | Plan Code | Accept Qty | Reject Qty | Reject Number | Insp. Stamp |
|--------------------------------|--------------------------|----------------------|---------|--------|--------------|---------------|---------------|------------------|----------------|
| Draw Nbr | Revision Nbr | | | | | | | | |
| D2524 | Rev A | | | | | | | | |

100

0.00



FLOW WATER JET

Waterjet

Memo

0.00

FLOW CNC Waterjet

1-Cut as per Dwg D2524 ☐ Dwg Rev: A ☐ Prog Rev: A ☐ 2-

Debur if necessary

6061 .25 x 2.50

B10-8-24

⑥

110

QC2- Inspect parts off machine FAI/FAIB

0.00



QC

Memo

0.00

Quality Control

B10-8-24

120

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control

8/10/08/24

④

PH →

Dart Aerospace Ltd

| W/O: 61251 | | WORK ORDER CHANGES | | | | | | |
|------------|----------------------------|--|---------------|---------------------|-----|-------------------------------------|--------------------------|--|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector | |
| 10/08/24 | # 100 100 | Perm. change ADD step to Alodine Per Q27005 as per Dwg. | HA | 10/08/24 | | | S 10/06/24 | |
| 10/08/24 | # 05 | Alodine part per Q27005 | HA | 10/08/24 | | | S 10/06/24 | |

Part No: D2524 PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
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NOTE: Date & initial all entries

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries

Work Order ID 61251

August 11, 2010 11:56:40 AM



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Item ID: D2524

Accept



Setup Start



Revision ID:

Stop



Item Name: Bracket Clamping

Start Date: 8/11/10 Start Qty: 5.00



Cust Item ID:

Required Date: 8/18/10 Req'd Qty: 5.00



Customer:

Reference:

Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

160

QC21- Final Inspection - Work Order Release

0.00

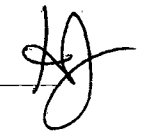


QC

Memo

0.00

Quality Control

10/08/31 
C2 10/8/31

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
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| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
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NOTE: Date & initial all entries

Picklist Print

August 11, 2010 11:56:40 AM

Page 1

Work Order ID: 61251



Parent Item: D2524



Parent Item Name: Bracket Clamping

Start Date: 8/11/10

Required Date: 8/18/10

Start Qty: 5.00

Required Qty: 5.00

Comments: IPP C000.06.26 Removed P/O for powder coat EC
IPP Rev: D Now on Waterjet 08-01-08 JLM Verified By:EC

| Component Item ID/ Item Name | Replacement Item ID | Mfg/ Purch | Bin Item | Primary Location | Last Location | Route Seq ID | Unit of Measure | Qty on Hand | Qty per Kit | Total Qty | Qty Issued | Date Issued | Status |
|---------------------------------|------------------------|---------------|-------------|---------------------|------------------|-----------------|--------------------|----------------|-------------|--------------|---------------|----------------|--------|
| M6061T6B0.250X02.50 0 | | Purchased | No | | | 100 | f | 30.4134 | 0.7292 | 3.837895 | 4.4 | | |



8-10-8-24

6061-T6 Bar 0.25 x 2.50

| Location | Loc Qty | Loc Code |
|----------|---------|----------|
| MAT01 | 30.4134 | |
| 101000 | 9.25 | |
| 106652 | 20 | |
| 15427 | 1.1634 | |

~~107131~~

101000

6

~~107131~~

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

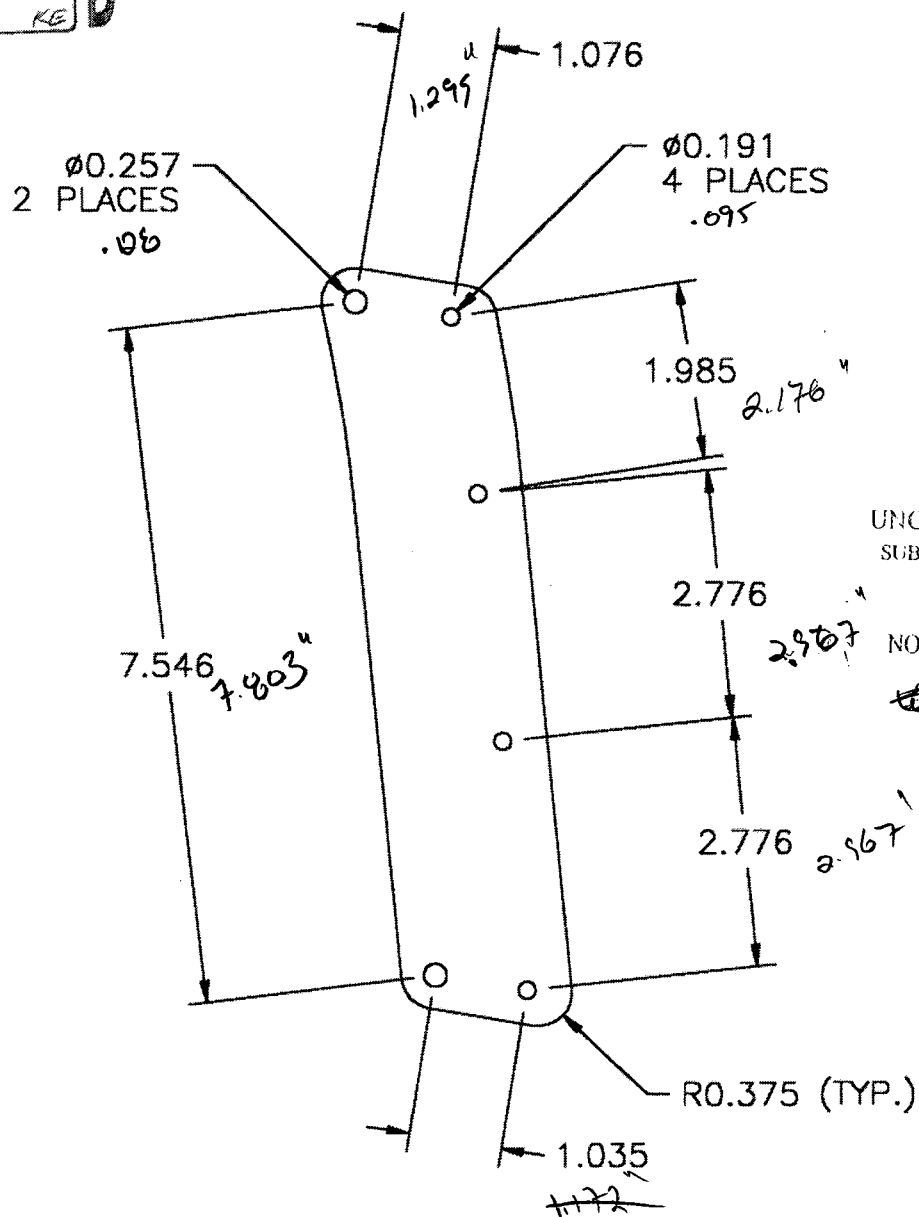
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NOTE: Date & initial all entries



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|-------------------------------|--------------------------------|--|------------------------|
| DESIGN <i>By</i> | DRAWN BY <i>KE</i> | DART AEROSPACE LTD VICTORIA INTERNATIONAL AIRPORT, CANADA | |
| CHECKED <i>[Signature]</i> | APPROVED <i>[Signature]</i> | DRAWING NO. D2524 | REV. A SHEET 1 OF 1 |
| DATE 95.12.20 | | TITLE SIDE PLATE | SCALE 1:2 |
| A | 95.12.20 | NEW ISSUE | |

RELEASED
97/07/19 KE
ECN001



SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 61251
CL 10/8/11

MATERIAL: 6061-T6 QQ-A-200/8 0.25 THICK
FINISH: ACID ETCH, ALODINE PER DART QSI 005 4.1
POWDER COAT GLOSS WHITE PER DART QSI 005 4.3

128
95
223
1035
223
1-258